Work Ord November-09-1				*928	329*						Page 1	
tem ID: Revision ID:	D4030-041		11.00	Accept	*N900	040	100)* s	etup Stai	I VI	S1*	
tem Name:	Long Basket	Assembly (350)							Sto	P *N.	S2*	
Start Date:	11/09/12	Start Qty: 1.00	*1*		Cust Item	ID:						
Required Date	: 11/27/12	Req'd Qty: 1.00	*1*		Customer:							
Reference:			. -									
Approvals:	Process Pl	an: MLJ	Date: 12-11-C	Tooling:	D	ate:		R	tun Sta	1/1	R1*	ata an a
	QC:		Date:	SPC (Y/N):	D	ate:			Sto	*N	R2*	
Sequence ID/ Work Center I		Operation Description	<u> </u>	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stämp	
Draw Nbr	Re	vision Nbr										
D4030	C											
100		Pick Kit		0.00								
100 Packaging Packaging		Memo		0.00				·			ામામ	21 J B
110		Assemble as per dwg		0.00							and the second s	
*11 0 *		Assemble as per dwg		0.00				١.	1	110	12	100
HandFinish		Memo		0.00				<u> </u>	-4-		-12101	1105
Hand Finishing			label plate to size of D408 for label, apply label		ed pad to lightly							
¹²⁰ *12∩*		QC5- Inspect part comp	pleteness to step on W/O	0.00 DA				1				
QC Quality Control		Memo		0.00 /3	1-7							

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE	QA Closed:	Date:	:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part f	- . No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												•	
							AUI	T CATE	GORY	·			
Landi	ng G	iear				General					_		
	┝──┤	Bending Centre No	ot Concer	ntric to (o/s	Bend BOM/Route		Grain Hardwa	re		Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

November-09-12	1:40:23 PM			. , , ,			-, , <u>-</u>			
Item ID: Revision ID:	D4030-041			Accept	*N90004010) () *	Setup	Start	*NS1	*
	Long Basket A	ssembly (350)						Stop	*NS2) *
Start Date: Required Date:	11/09/12 11/27/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:					
Reference:		n:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1	* *
Sequence ID/ Work Center II 130 *130* Packaging		Operation Description Identify as per dwg & St	ock Location:	Set Up/ Run Hours 0.00	Tool ID Tool # Plan		ept Re		Reject Insp Number Star	•
140 *140* QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00			<u> </u>	3/1/	19 \$	-

W12-01-14

											DQA:	Date:	<u> </u>
NCR:	Yes	/ No				WORK ORDER NON-O	CON	FOR	MANCE / UP	DATE			`
											QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part f	- No					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	In	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
					l	F	AULT	CATE	GORY		!	<u> </u>	<u> </u>
Landi	ng G	ear				General					_		
		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W	Crimped. t n Strip in Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Turning Se	equence			Finish		Out of S	Sequence				•

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

November-09-12 1:40:22 PM

Work Order ID:

92829

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

Start Date: 11/09/12

Required Date: 11/27/12

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

10.04.20 verified by:EC

3.23 verified by:EC IPP Rev:B as per dwg revB DD IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530 Handle Weldment		Manufactured	No			100	Each	8.0000	1 9	4030	JB		
				Location		Loc Oty	Lo	oc Code					
				ST255		6							
				92129	9	6							
				ST506		2							
				8289:	5	1							
				83423	3	1							
D2535		Manufactured	No			100	Each	120.0000	2	2	70		
Spring									~ ***				
				Location		Loc Qty	L	oc Code					
				ST011		120							
				8354	5	3			-71	797			
•				8633		67			30	333			
				9257	0	50							
D2537		Manufactured	No			100	Each	74.0000	2	2	1.8		
Bushing											f?		
	•			Location		Loc Qty	<u>L</u>	oc Code					
				ST012		74				660 1(
				8550		32				5504			
				8686		2 40		•					
			M.	8752	.4		Fash	0.0000				α. Λ	, 1
D3913-041 Long Basket Base Assemb	ру, 350	Manufactured	No			100	Each	0.0000	189	3761	LXJ_	<u> </u>	3/01/0
D3914-041 Long Basket Lid Assembly	y (350)	Manufactured	No			100	Each	0.0000	130	14047	2 (x1)	M,	3/0/

											DQA:	Date:	_
NCR:	Yes	/ No					WORK ORDER NON-C	100	VFORM	MANCE / UPDATE	·		
											QA Closed:	Date:	
Nork Ord	er:						DISPOSITION			AGAINST D	EPARTMENT,	/PROCESS	,
Part NCR	No.						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
								1					J 1
Root					Des		ption of work order update	1	nitial	Action	Sign &		
Cause	_	Date	Step	Qty	_	C	or Non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved													
							F/	AUL	T CATE	GORY			•
Land	ng (Gear					General		-	_	_		_
		Bending Centre No Cracks Crushed/C Cuffs Heat Trea Inspection Ripples in	Crimped. t n Strip in Bend	Tube			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Unclear enance eled	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	<u> </u>	Torque W		xtrusior	۱		Drawing		1	Calibration			
		Turning Se	equence				Finish		Out of S	Sequence			

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:	92829							
Parent Item:	D4030-041					Start	Date: 11/09/12	Required Date: 11/27/12
Parent Item Name:	Long Basket Assembly (350)					Start	Qty: 1.00	Required Qty: 1.00
D3917-3 Washer	Manufactured	No		100	Each	41.0000	6	6 - JB
			Location	Loc Qty		Loc Code		V
			ST072	41				
			88370	41			8837	
D3953-3 Gas Spring Stud, Lid	Manufactured	No		100	Each	47.0000	2	2 - JB
			Location	Loc Qty		Loc Code		/
			GA	1				
			87592	1				_
			ST076	46				
			88494	26				-
			89337	20			89337	7 -
D3953-7 Spring Spacer	Manufactured	No		100	Each	51.0000	2	² - gB
			Location	Loc Oty		Loc Code		
			ST076	51				_
			87444	15	i			_
			88393	24			88393	5 -
			89248	12	:			-
D3953-9 Gas Spring Washer	Manufactured	No		100	Each	45.0000	2	2 18 12/12/21
			Location	Loc Qty		Loc Code		
			ST076	45	;			_
			88462	15				_
	•		89307	30)		89307	<u> </u> -

												DQA:	Date	<u>:</u> : _	
NCR:	Yes	/ No					WORK ORDER NON-C		NFORM	MANCE / UPDATE					
												QA Closed:	Date): 	
Nork Ord	er:						DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		·
Part NCR	No.						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Machining Small Fal noforming Finishing Large Fab Composite	b g	4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
							Work order opdate	1		carge ras compositi	`Ш	J	adbure. [
Root					Desc		otion of work order update	i i	nitial	Action		Sign &		T	
Cause		Date	Step	Qty		С	r Non-conformance	Ch	ief Eng	Description		Date	Verification	\bot	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved															
							F/	AUL	T CATE	GORY		•			
Land	ing (Gear					General				_	_	_		
••		Bending Centre No Cracks Crushed/C Cuffs Heat Trea Inspectior Ripples in	Crimped. t n Strip in		O/S		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		1 '	ion Incomplete ions Incomplete/Unclear enance eled		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque W	aves in E	xtrusio	n [Drawing		Out of (Calibration					
		Turning Se	equence				Finish		Out of 9	Sequence					

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:	92829								•
Parent Item:	D4030-041			÷		Start I	Date: 11/09/12		Required Date: 11/27/12
Parent Item Name:	Long Basket Assembly (350)					Start	Qty: 1.00		Required Qty: 1.00
D3953-17 Gas Spring Spacer	Manufactured	l No		100	Each	51.0000	2	2	JA
			Location	Loc Oty		Loc Code			V
			ST077	47					
			88281	21			88	281	
			89180	26					
			ST078	4					
			87291	4					
D3953-19 Gas Spring Bracket	Manufacture	No No		100	Each	11.0000	1	1	-JB
			Location	Loc Qty		Loc Code			·
			ST077	11					
•			82938	1			- 0.0	· .	
			88269	10			22	269	
D3953-21 Gas Spring Bracket	Manufacture	j No		100	Each	16.0000	1	1	-JB
			Location	Loc Oty		Loc Code			
			ST077	16					
			85759	16			83	75	9
D3969-3	Manufacture	d No	•	100	Each	28.0000	1	1	
Spring (Basket Lid)								· · · · · · ·	13
			Location	Loc Qty		Loc Code			,
			ST262	28					
			64285	1					
			82942	7					4
			91844	20			9/2	844	
AN3-14A Bolt	Purchased	No		100	Each	105.0000	4	4	20 12/12/2
			Location	Loc Qty		Loc Code			
			ST512	105					
			121708	5					
			122800	100			123	800	

NCR: Yes / No	WORK ORDER NON-CON	FORMANCE / UPDATE
		QA Closed:
Work Order:	DISPOSITION	AGAINST DEPARTMENT/PR
	Rework	Skid-tube Crosstube
Part No.	Scrap	Machining Small Fab Prod.

N. 10	cs /	IVO				WORK ORDER HOR-	CO		VIAIVEL / OF	DAIL	QA Closed:	Date:	• •
k Ordei	r·					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
K Oluci	·					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	o					Scrap	_		Machining	Small Fab	4	d. Eng. Coor.	Quality
						Use-as-is			noforming	Finishing	Rec/Sto	re/Packaging	Other •
NCR N	o. <u> </u>					Work Order Update	ا		Large Fab	Composite	j	Supplier	
oot					Descri	ption of work order update	Τ	Initial	Ac	tion	Sign &		
use	D	ate	Step	Qty		or Non-conformance	Cl	nief Eng	Desc	ription	Date	Verification	QC Inspector
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roved		- 1		1									[
							FAU	LT CATE	GORY				
Landin	g Gear					General							
	Ben	nding				Bend	Г	Grain			Ovalized		Pressure/Forced
	Cen	ntre No	t Concer	ntric to C	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crad	cks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crus	shed/C	rimped.			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
Ī	Cuff	fs				Contamination		Mainte	nance		Part Moved	t	•
	Hea	at Treat				Countersink		Mislabe	led		Positioned V	Vrong	
r	insp	pection	Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	_	Other
	 i	ples in				Drill Holes		Offset		<u> </u>			<u> </u>
F	⊣ ''	•		xtrusion	,	Drawing		-∤	Calibration				
-		•	quence			Finish	Out of Sequence						
		_	st in Tub			Folio	Outside Dimensions					· · · · · · · · · · · · · · · · · · ·	

DQA: _____Date:

Root Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:	92829					-					
Parent Item:	D4030-041				•			Date: 11/09/12		Required Date: 11/27/	12
Parent Item Name:	Long Basket Assembly (350))					Start	Qty: 1.00		Required Qty: 1.00	
AN3-16A Bolt	Purcl	hased No	•		100	Each	131.0000	2	2	73	
			Location	n	Loc Qty		Loc Code			•	
			ST512	_	131		-				
				117441	47						
				118628	1						
				122407	83			1224	107		
AN5-17A	Purc	hased No)		100	Each	132.0000	4	4		
Bolt											
			Locatio	<u>n</u>	Loc Oty		Loc Code			U	
			338		4				_		
				121181	4				_		
			ST337		88						
				122416	50			3 7 2 24	<u>طرا</u>		
				122800	38			141228	0		
			ST338		40						
				117872	34						
				122151	6				_		
AN4-12	Purc	hased N)		100	Each	90.0000	3	3	11B	
Bolt											
			Locatio	<u>n</u>	Loc Oty		Loc Code				
			ST356		88				_ \		
				122800	88			122	860	•	
			ST357		2						
				118626	1						
				121652	. 1			-	_		
AN310-4	Purc	hased N	0		100	Each	63.0000	3	3	~ ₂ B	12/12/2
NUT										<i></i>	10/12/0
			Locatio	<u>on</u>	Loc Qty		Loc Code				
			ST342		61						
•				122800	61			1228	00		
			ST344		2	!					
				121349	2	!					

											DQA:	Dat	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE				-	
						V			······		QA Closed:	Dat	te:	,
Work Ord	er:					DISPOSITION			AGAINS	T DE	PARTMENT	PROCESS		
Part I	Part No. NCR No. Root Cause Date Step Qty c/Data pip/Tooling erator pterial pup ner pocess poplier plining			Rework Scrap Use-as-is Work Order Update Rework Skid-tube Machining Small Fab Thermoforming Large Fab Composite			4	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other				
Root					Descri	ption of work order update		Initial	Action		Sign &		\Box	
Cause		Date	Step	Qty	C	or Non-conformance	Ct	nief Eng	Description		Date	Verification	n .	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
				·		 -	AUI	LT CATE	GORY					
Landi						General	_	٦			7	1		l .
	-	_			<u> </u>	Bend		Grain		<u> </u>	Ovalized		-	Pressure/Forced
	\vdash		t Concer	ntric to	0/s	BOM/Route		Hardwa			Over/Under		${f -}$	Temperature/Cure
	-					Broken/Damaged	\vdash	4	on Incomplete	L	Part Incorred	it .	\vdash	Weld
	Ш	Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/Unclear	L	Part Lost/Mi	ssing	\bigsqcup	Wrong Stock Pulled
		Cuffs				Contamination	L	Mainte	nance	L	Part Moved			
	1 1	Heat Trea	t			Countersink		Mislahe	led	Γ_	Positioned W	/rong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 92829 Required Date: 11/27/12 D4030-041 **Start Date:** 11/09/12 Parent Item: Required Qty: 1.00 Long Basket Assembly (350) Start Oty: 1.00 Parent Item Name: 100 75.0000 AN310C4 Each No Purchased Nut Loc Code Location Loc Qty ST343 73 122800 23 122800 50 122993 2 ST344 120360 121166 100 Each 2,433,0000 MS21042L3 Purchased No JB 12/12/21 Nut Loc Qty Loc Code Location 316 619 619 122452 ST300 225 32 117885 119017 55 119075 138 ST314 1268 1268 123265 ST317 321

122141

321

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE			
											QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	ŕ
Part I	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause	,	Date	Step	Qty	C	or Non-conformance	Cr	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												·	
							AUL	T CATE	GORY				
Landi		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection	Crimped. It n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misread	on Incomplete ions Incomplete/U nance led	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	1	Ripples in	Bend			Drill Holes	1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: Parent Item: Parent Item Name:	92829 D4030-041 Long Basket Assembly (350)						pate: 11/09/12 Qty: 1.00		Required Date: 11/27/12 Required Qty: 1.00
MS21042L5 Nut	Purchased	No		100	Each	1,041.0000	4	4	76
		Locat	<u>ion</u>	Loc Qty		Loc Code			·
		300		29					
			121652	29					•
		314		932					
			122452	932			1221	152	.
		ST300)	80					
			108827	4					
			116105	1					
			116548	43					
			119109	20 12					
		N	2937		F1	227,0000			_
MS24665-151	Purchased	No		100	Each	236.0000	3	3	10
Cotter Pin	•								
		Locat	<u>ion</u>	Loc Oty		Loc Code			
		ST323		236					_
			122802	162			1229	703	
			17566	74					
MS24665-300 Cotter Pin	Purchased	No		100	Each	79.0000	2	2	23 /2//2/2
		Locat	tio <u>n</u>	Loc Oty		Loc Code			•
		GA		75					
			118234	75			1183	134	
		ST309	9	4				•	
		3.00	116823	4					

DQA:

Date:

NCR:	Yes	/ No					WORK ORDER NON-C	COI	NFORM	MANCE / UP	DATE	QA Closed:	Date:	», '	
						-									
Vork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part							Rework Scrap		ſ	Skid-tube Crosstube Machining Small Fab			Water Jet d. Eng. Coor.	Engineering Quality	
NCR	No.										Finishing Composite	Rec/Store/Packaging Other Supplier			
Root					Des	cri	ption of work order update		nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty		C	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector	
oc/Data															
quip/Tooling												!			
perator								İ							
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etup	_						•	•							
ther			<u> </u>												
rocess	H	}													
upplier raining	_														
napproved	_							1					-		
паррточеи	L		<u>l</u>	<u> </u>			F	AUL	T CATE	GORY		1			
Landi	ng (Gear					General								
	Ť	Bending					Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	ot Concer	ntric to	o/s		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld	
		Crushed/0	Crimped.				Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
		Cuffs					Contamination		Mainte	nance		Part Moved		_	
		Heat Trea	t				Countersink		Mislabe	led		Positioned V	Vrong	_	
	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs General Bend BOM/Route Broken/Damaged Burrs Contamination				Cut Too Short		Misread	I		Power Loss/	Surge	Other			
	lacksquare				Drill Holes		Offset		_						
		Torque W	aves in E	xtrusio	n		Drawing		Out of C	Calibration					
		Turning Se	equence				Finish		Out of S	equence					
		Wave/Tw	ist in Tub	oe .		l	Folio		Outside	Dimensions					

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Work Order ID:	92829										
Parent Item:	D4030-041						Start Da	ate: 11/09/12		Required Dat	e: 11/27/12
Parent Item Name:	Long Basket Assembly (350)						Start Q	2ty: 1.00		Required Qt	y: 1.00
NAS1149F0432P Washer	Purchased	No			100	Each	476.0000 .	6	6	- JB	
			Location		Loc Qty		Loc Code				
			275		24	}					
				122441	24	}					
			ST275		2	3					
				121350	1						
				122151	1	3					
			ST295		20						
				123522	20			123:	778		
NAS1149F0563P Washer	Purchased	No			100	Each	826.0000	4	4	~ 23	
			Location	<u>l</u>	Loc Qty		Loc Code				
			ST275		82	5					
				121350	82	6		121	350		
NAS1149F0332P WASHER	Purchased	No			100	Each	1,182.0000	8	8	JB	12/12/2
			Location	<u>1</u>	Loc Qty		Loc Code				• •
			275		20	6					
				122441	20	6					
			ST275		77	6					
				117735	1	3					
				119225		8					
				121259	13						
				121825		4					
				122063	60						
				17317		3					
			ST295		20			122	25 2		
				123352	20	0		123:	728		

										DQA:	Date	e:	
NCR:	Yes / No				WORK ORDER NON-C	OI	NFORM	MANCE / UPE	DATE	QA Closed:	 Date	e:	
Work Orde	ar.				DISPOSITION			· · · · · · · · · · · · · · · · · · ·	AGAINST DE	PARTMENT,	/PROCESS		
Part N	No				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining Moforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				Descri	ption of work order update		nitial	Act	ion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector	
Doc/Data								•					
Equip/Tooling													
Operator										•			
Material													
Setup		}											
Other												1	
Process													
Supplier		ļ											
Training													
Unapproved		ĺ				1							
					F	AUL	T CATE	GORY					_
Landii	ng Gear				General			•				<u> </u>	_
	Bending				Bend		Grain		Γ_	Ovalized		Pressure/Forced	
	Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	-	Weld	
	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/L	Inclear	Part Lost/Mi	issing	Wrong Stock Pulled	d
	Cuffs	-			Contamination	\Box	Mainte	•		Part Moved	- [
	Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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November-09-12 1:40:22 PM

Work Order ID:

92829

Parent Item:

D4030-041

Parent Item Name:

NAS1149C0432R

Washer

Long Basket Assembly (350)

201.8 2 401.01 1

Purchased

No

Start Date: 11/09/12

Required Date: 11/27/12

Start Qty: 1.00

Required Qty: 1.00

4,340.0000 **2**

2 / B 12/12/21

			•
Location	Loc Qty	Loc Code	
296	3000		
122441	3000		
ST297	1036		<u>.</u>
117291	40		
119124	996		119124
ST298	304		
121255	304		

Each

100

										DQA:	Da	ite:	•
NCR:	res / No				WORK ORDER NON-O	OI	NFOR	MANCE / UPDATE		QA Closed:	Da	ite:	, t
Work Orde	er:				DISPOSITION			AGAINST	DE	PARTMENT	PROCESS		
Part N	Part No. NCR No. Root Cause Date Step Qty Oc/Data quip/Tooling				Scrap Machining Thermoforming Work Order Update Large Fab			Machining Small Fab		-†	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root		ŧ		Descri	ption of work order update		nitial	Action		Sign &	··· ·· · · · · · · · · · · · · · · · ·		,
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verificatio	'n	QC Inspector
Doc/Data													
Equip/Tooling								•					
Operator													
Material		İ											
Setup													
Other													
Process				ļ									
Supplier													
Training													
Unapproved													
					F	AUL	T CATE	GORY					
Landi	ng Gear				General		_			_			
	Bending				Bend		Grain			Ovalized			Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure
	Cracks			L	Broken/Damaged		Inspecti	on Incomplete		Part Incorred	:t		Weld
	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
ĺ	Cuffs				Contamination		Mainte	nance		Part Moved			-
	Heat Trea	at			Countersink		Mislabe	led		1 Positioned V	/rong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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					3
ЕМ	QTY -041	QTY	P/N	DESCRIPTION	
,	х		D4030-041	LONG BASKET ASSY (350)	
_		х	D4030-043	LONG BASKET ASSY, LIGHT LID (350)	
		7			
1 1 0				HANDLE WELDMENT	
2 2 D25				SPRING	
			D3913-041	BUSHING	
1			D3914-041	LONG BASKET BASE ASSY (350) LONG BASKET LID ASSY (350)	
	••		D3915-041	LIGHT LID ASSY-LONG BASKET	(5)
6	+		D3917-3	WASHER	
2			D3953-3	GAS SPRING STUD, LID	
	2		D3953-7	GAS SPRING SPACER	S S Carlotte S Carlott
	2		D3953-9	GAS SPRING WASHER	
	2		D3953-17	GAS SPRING SPACER	
1	П	1	D3953-19	GAS SPRING BRACKET	
	1	1	D3953-21	GAS SPRING BRACKET	because to all the state of the
	1	1	D3969-3	SPRING	
	4	4	AN3-14A	2017	
	2	4	AN3-14A AN3-16A	BOLT BOLT	
	-	2	AN3-20A	BOLT	
_	3		AN4-12	BOLT (DRILLED)	
	4		AN5-17A	BOLT	
-	_		AN5-21A	BOLT	The state of the s
	3		AN310-4	NUT, CASTELLATED	
	2		AN310C4	NUT, CASTELLATED	
	6	6	MS21042L3	NUT	
	4	4	MS21042L5	NUT	14
	3		MS24665-151	COTTER PIN	
	2		MS24665-300	COTTER PIN	
	6		NAS1149F0432P	WASHER	PAGE AND PAG
	4		NAS1149F0563P	WASHER	D4030-041 LONG BASKET ASSY (350) (MESH SHOWN LOCALLY FOR CLARITY)
_	8		NAS1149F0332P	WASHER	(WESH SHOWN LOCALLY FOR CLARITY)
L	2		NAS1149C0432R	WASHER	
		<u> </u>			
		~		•	
					/
					(4)
				SHOP CORE	DELEASED TO THE PROPERTY OF TH
					THE THE TOTAL PROPERTY OF THE TOTAL PROPERTY
				RETURNS OF	10.08.12 (1')
				PNCASE SE	ECN 10-596
					DAGGO GAG LONG BAGKET AGGY LIGHT LIGHT (GAG)
			· 1	UNCONTROLL B	D4030-043 LONG BASKET ASSY, LIGHT LID (350) (MESH SHOWN LOCALLY FOR CLARITY)
				SUBJECT TO AND N	1 QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING
					C (BB-1); OTY FOR ITEM 83 WAS 4 (DB-1), ONLY 2 ARE MB 10. REQUIRED, AFFORTS SPECTION, CAC, OTX-3.
				WiTHOUT OF	D AND DAY BOLL THIS AND AND AND AND AND AND AND AND AND AND
				VIIII (V	A NEW ISSUE JPH 10
				MID AND	REV. DESCRIPTION BY D
				(3/) (3/01 /01/0	
-	TES:			NO 92861	DESIGN ALS DART AFROSPACE ITD
`	TES:	RIAL: H: NO	N/A	NO 92829 MLJ 12-11-	DESIGN ALS DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 041: 72 lbs APPROX
-043: 57 lbs APPROX

С	QTY FO (B8-1); (REQUIR	OR ITEMS OTY FOR RED, AFF	S#30 & RITEM# ECTS S	#31 UNDER -043 WERE MISSING #3 WAS 4 (D6-1), ONLY 2 ARE SECTION C-C (D3-3).	мв	10.07.23				
В				I5-19A: BOM & (D3-3)	JPH	10.04.06	1			
Α	NEW IS	SUE			JPH	10.03.16	1			
REV.			, (DESCRIPTION	CRIPTION BY DATE					
DESIGN	1	1	2	DART AEROSPACE LTD						
DRAW	1		4	HAWKESBURY, ONTARIO, CANADA						
CHECK	ED	-0	9	DRAWING NO.		REV. C	1			
MFG. A	PPR.	563	25.	D4030		SHEET 1 OF 3	ĺ			
APPRO	VED	J./W	J	TITLE		SCALE	1			
DE APP	R.	4	#-	LONG BASKET_ASS	Y.(350))NTS				
DATE	10.0	7.23		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS STRIKE WIS CONSIDERING, WIS A SUPPLIES ON THE EDITESS CONSIDERING THAT IT IS NOT TO BE USED FOR ANY APPOSES OR COPYRIGHT OF ANY OTHER PLATFOR WITHOUT						

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